

Work Order ID 82192

Saturday, March 24, 2012 11:53:30 AM

82192

Page 1

Item ID: D3319-7

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Wearplate

Stop

NS2

Start Date: 3/26/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 3/30/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: umf

Date: 12-03-24

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3319

pc1

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3319

Dwg Rev: pc1

Prog Rev: pc1

2-Deburr if necessary

12-3-24

(13)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12-3-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
				5.2103/27	(43)				
140 *140* Brake NC Brake NC	NC BRAKE Memo Form using DT8326 & DT8261 as per Dwg D3319 Rev: <i>pc1</i>	0.00 0.00							
				5.1203/26	(13)				
150 *150* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00							
				5.1203/27					

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Required Date: 3/30/2012 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	Large Fab	0.00							
160									
Large Fab	Memo	0.00							
Large Fab	Weld hard surface using D3319-7T2 per QSI 004 and Dwg D3319 Batch A/R 7560 Hardcoat Rod <u>m119712</u>								

(x13) ME / MAL 12-03-29

170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00							
Quality Control									

8, 26/3/12

180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									

8 ref/12/12

(x13)

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
190						13	2	(2P)	12/03/29.
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 10h10								
	OVEN TEMPERATURE: 320°F								
	FINISH TIME: 10h40								
200	QC3- Inspect Part Finish	0.00							
200						13	12	12 3-29	
QC	Memo	0.00							
Quality Control									
210	Packaging	0.00							
210									
Packaging	Memo	0.00							
Packaging	Identify on inside surface using a permanent fine point marker with the following:TCCA-PDA, Dart Aerospace Ltd.P/N: D3319-7, B/N: BXXXXXFor Product Eligibility see PDA05-18 and Stock								
	Location: 497								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

MLJ 12/03/29

12-03-29

W/O:		WORK ORDER CHANGES					
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Picklist Print

Saturday, March 24, 2012 11:53:30 AM

Page 1

Work Order ID: 82192

Parent Item: D3319-7

Parent Item Name: Wearplate

Start Date: 3/26/2012

Required Date: 3/30/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: A05.05.12New issue KJ/JLM
IPP Rev:B Now on Waterjet 07-06-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA 1010/1025 SHEET .048		Purchased	No			110	sf	99.2960	0.548	6.9221053		8/13/12-3-24	

Location

Loc Qty

Loc Code

MAT019

99.296

116268

3

117806

96.296

117806

13

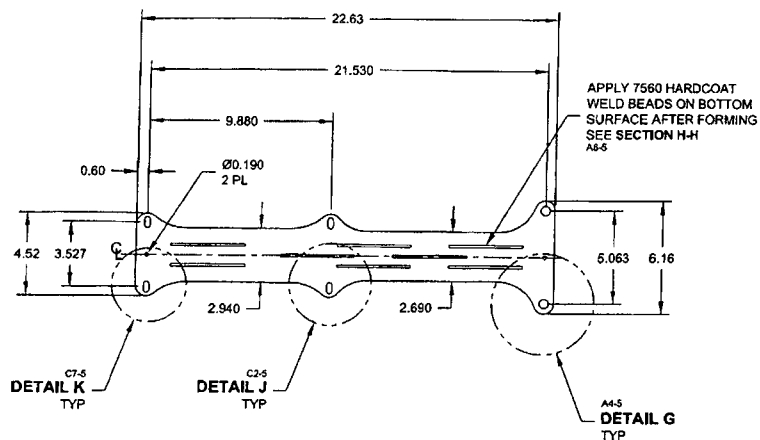
W/O:		WORK ORDER CHANGES					
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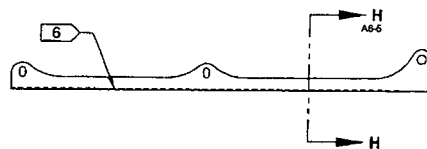
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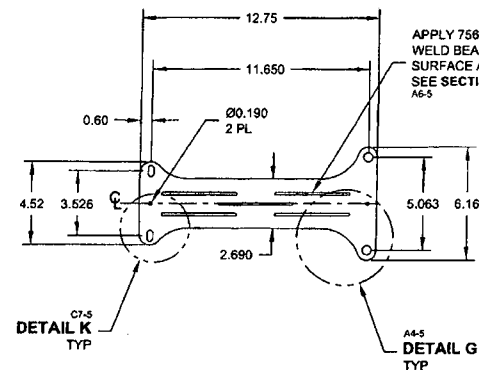
NOTE: Date & initial all entries



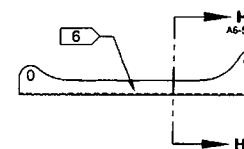
D3319-5F FLAT PATTERN



D3319-5 BENDING DETAIL
MAKE FROM D3319-5F



D3319-7F FLAT PATTERN



D3319-7 BENDING DETAIL
MAKE FROM D3319-7F

#8792

D3319-5/-7 WEARPLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-X B/N XXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 046 6.1 (PERMANENT MARKER)
- 7) WEIGHT: D3319-5 = 1.05 lbs APPROX; D3319-7 = 0.60 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2012-02-16

912.5316

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3319	SHEET 3 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		WEARPLATE	NTS
DE APPR.		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.03.13		

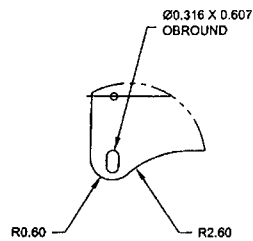
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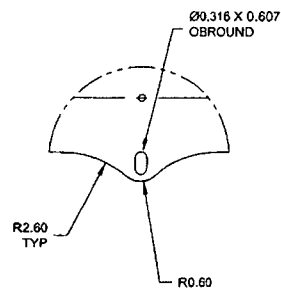
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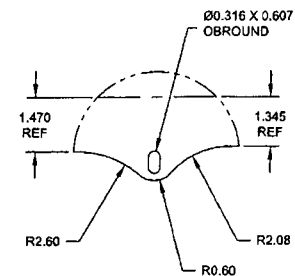
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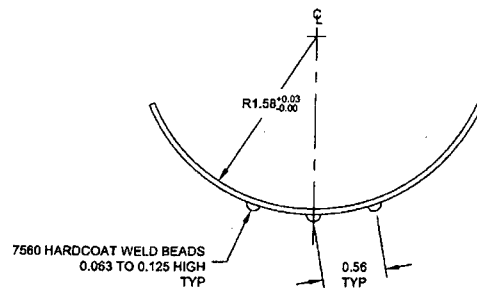
DETAIL K
SCALE 2X
B8-2
C4-3
C9-3



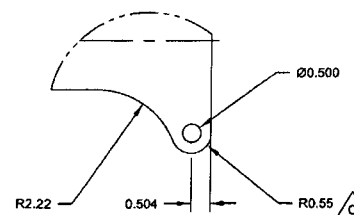
DETAIL F
SCALE 2X
B3-2



DETAIL J
SCALE 2X
B8-2
C7-3



SECTION H-H
SCALE 4X
B4-2
B4-3
B6-3



DETAIL G
SCALE 2X
B8-2
C2-3
C6-3

RELEASED
2012-02-16
412.03.16

DESIGN	PH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3319	REV. C
MFG. APPR.		TITLE WEARPLATE	SHEET 4 OF 4
APPROVED		SCALE	NTS
DE APPR.			
DATE	12.03.13	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Dart Aerospace Ltd

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